

# Work Order ID 52551

September 30, 2009 10:34:20 AM



Page 1

Item ID: D3656-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: PANEL

Start Date: 30/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 15/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*

Date: *09-9-30*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3656	Rev B								
100		0.00							
	HAND FINISHING THERMOFORMING								<i>BB 09/10/06</i> <i>(X4)</i>
Thermoform	<b>Memo</b>	0.00							<i>X2</i>
Thermoforming Machine	Cut Blanks to fit frame size								<i>09/10/04</i>
110		0.00							
	THERMOFORMING MACHINE								<i>BB 09/10/04</i> <i>(X6)</i>
Thermoform	<b>Memo</b>	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987 <input checked="" type="checkbox"/> Dwg. Rev. <i>B</i> <input type="checkbox"/> Folio Rev. <i>B</i>								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								<i>BB 09/10/05</i> <i>(X6)</i>
QC	<b>Memo</b>	0.00							
Quality Control	Visually inspect for proper formation of each part								

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

OK 09/10/15  
(x6)

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3656

OK 09/10/15  
(x6)

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

OK 09/10/15

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September 30, 2009 10:34:20 AM



Page 3

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	27 Sept 19			④	q		
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00				9/10/19		④	sf
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00				09/10/20		MF	

MF  
09-10-20

# Picklist Print

Page 1

September 30, 2009 10:34:19 AM

Work Order ID: 52551



Parent Item: D3656-3RevB



Parent Item Name: PANEL

Start Date: 30/09/2009

Required Date: 15/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,385.812	138.6400			
GE PLASTICS LEXAN SHEET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1385.812653

107574

16.62

111973

190.526053

112176

1178.6666

6

BB 09/10/19

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	52551
<b>Description:</b> Panel		<b>Part Number:</b>	D3656-3
<b>Inspection Dwg:</b> D3656	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB Date: 09/10/15

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	0.042	✓		Visual	
0.045	Min	0.045	✓		Visual	
0.050	Min	0.075	✓		Caliper	
60.25	REF	60.25	✓		TAPE	
40.75	REF	40.70	✓		TAPE	
0.7	REF	0.625	✓			

Measured by: D. Legu Date: 09/10/15  
Audited by: BB Date: 09/10/15  
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	



